










Date: Tuesday, 16/12/2008 2:15:16 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LONG STEP ASSEMBLY HIGH SKID RH
Job Number	: 44132		
Estimate Number	: 10274		
P.O. Number	:	Part Number	: D350591312
This Issue	: 16/12/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3272 REVB
First Issue	: //	Project Number	: N/A
Previous Run	: 43398	Drawing Revision	: B
Written By	:	Material	:
Checked & Approved By	: <u>2008-12-16</u>	Due Date	: 09/01/2009
Comment	: Est Rev:A 04.03.22 New issue KJ/RF : Est Rev:B 07-06-09 Added D3572-1 JLM : Est Rev:C 08-04-02 ECN1163 DD verified by:EC : Est Rev:D 08-04-08 ECN1164 DD verified by:eC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
			
Comment: DOCUMENT CONTROL Photocopy bluefile and type labels as per PPP D350-591-312 CHG002			
2.0	D32721	Step	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) STEP BATCH: <u>B 44055</u>			
3.0	D30671	End Plate	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3067-1 End Plate <u>B 41447</u>			
4.0	D32191	Plate	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3219-1 Support <u>B 41449</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Part Number: D350591312

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod M108037
M109560

3-Grind End Plate flush

Handwritten: 09.01.26 5
09.01.26 5
09.01.26 5

6.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: 09.01.26 (5)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 09.01.26 X5 PH

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: 09.01.26 5

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: SAD 09-01-26 (5)

10.0 D3065041 Step Leg Assembly Hi



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3065-041 Step Leg Assy 342344

Handwritten: 09.01.26 5

11.0 D30661 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3066-1 Spacer B43769

Handwritten: 09.01.26 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 44132

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W4

Rivet

1110468

PH 09.01.26 5

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble Leg Assembly as per Dwg D3272.

PH 09.01.26 5

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/26 *(ESRH)*

15.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3067-1

End Plate

341447

PH 09.01.27 5

16.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod 11108031

4-Grind End Plate flush

5-Install last rivet.

PH 09.01.27 5
PH 09.01.27 5
PH 09.01.27 5
PH 09.01.27 5
PH 09.01.27 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: D350591312

Job Number:



Seq. #: Machine Or Operation: Description :

17.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-01-28

18.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09-01-28 (5) RHE

19.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

BR 09-01-28 (5)

20.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

13:45

OVEN TEMPERATURE:

320°

FINISH TIME:

14:15

BR 09-01-28 (5)

21.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3272 and QSI 005 4.4

11109917

69-01-28 (5)

22.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

09-01-30 (5)

23.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0 D22303 Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2230-3 Mounting Lug

43223

JS 09-01-30 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: D350591312

Job Number:



Seq. #:	Machine Or Operation:	Description :
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25.0	D2618	Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2618 Bushing B42169

JS 09/01/30 (X)

26.0	D2856400	Abraison Strip
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Comment: Qty.: 0.6000 f(s)/Unit Total: 2.4000 f(s)

Abraison Strip

2 x D2856-400-720 42076

JS 09/01/30 (X)

27.0	D32351	Mounting Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3235-1 Mounting Lug 44052

JS 09/01/30 (X)

28.0	D3278041	Support Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3278-041 Support Assembly 44057

JS 09/01/30 (X)

29.0	AN335A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A Bolt M68827

JS 09/01/30 (X)

30.0	AN413A	Bolt
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Bolt

batch: M64746-110322

JS 09/01/30 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 44132

Part Number: D350591312

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

31.0	AN536A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5-36A Bolt

M110363

32.0	AN960JD10	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10 Washer

M169840

33.0	AN960JD416	Washer
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416 Washer

M110523

34.0	AN960JD516	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516 Washer

M169752

35.0	MS21042L3	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3)

M169798

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 44132

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 Nut (or -4) 1169282

37.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5 Nut (or -5) 1169287

38.0

DSI9410011

Step Modification



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Step Modification 44185

39.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

2090130 RH

40.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-312

Location: 12 Rev D 9/1/30

41.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/02

Job Completion



MF 09-01-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *ff*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

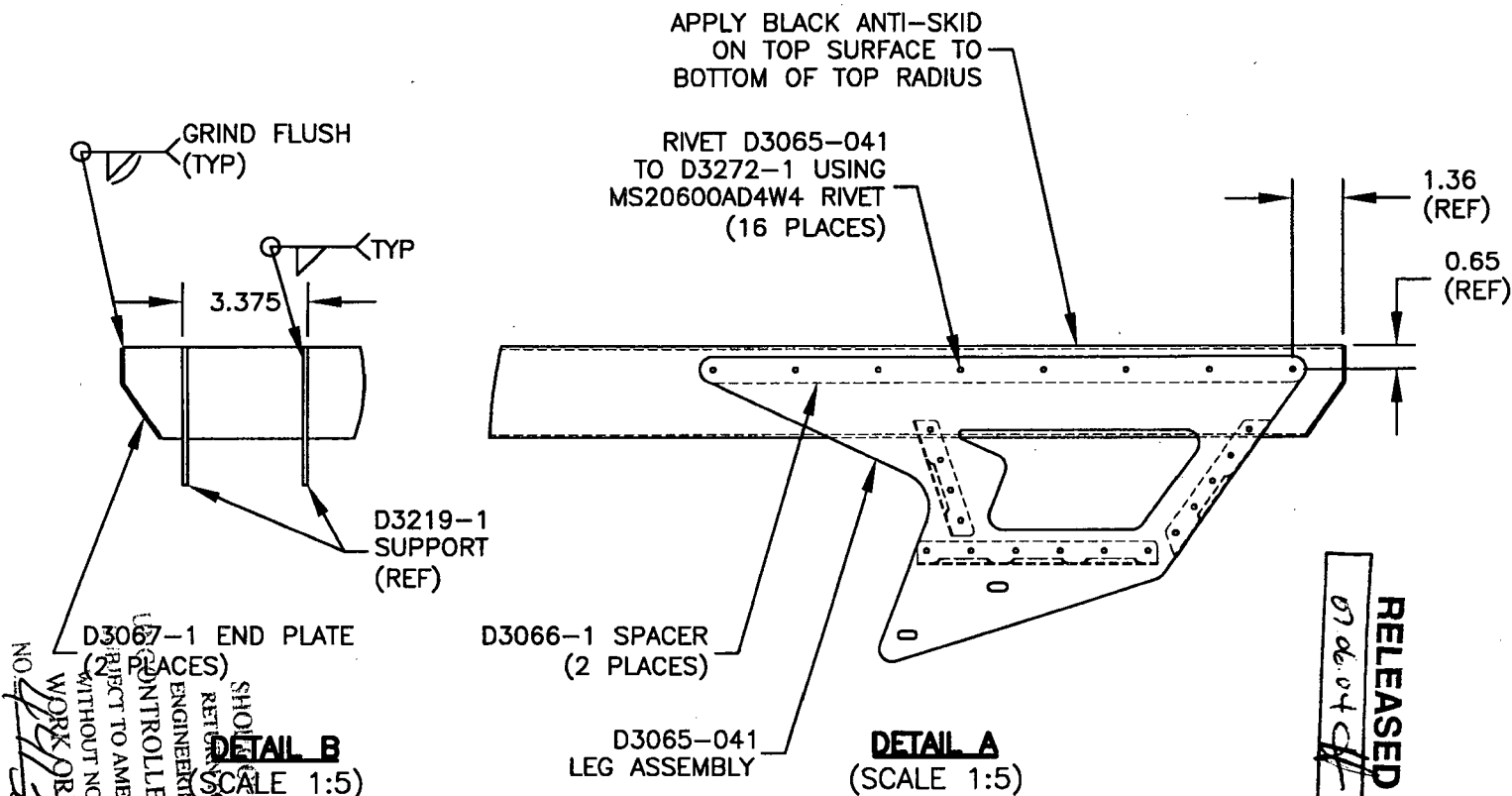
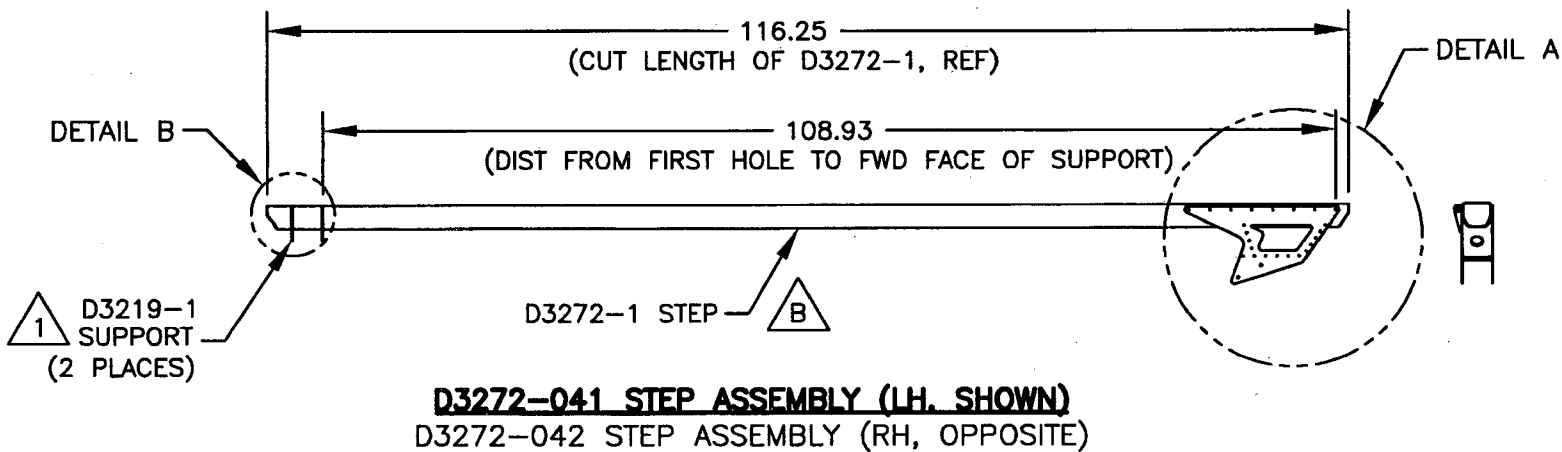
SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *44132*

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DART

DESIGN	QC	DRAWN BY	JR	DART AEROSPACE LTD
CHECKED	CE	APPROVED	JE	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE	1:20	



NO. 44933
WORK ORDER
SUBJECT TO AMENDMENT
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RETURN TO
SHOULY
NO. 44933